

Date: Wednesday, 2/20/2008 4:23:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HI-SKI STEP LEG		
Job Number	37542		Part Number	D2498		
Estimate Number	11832		Drawing Number	D2498 REV B		
P.O. Number			Project Number	N/A		
This Issue	2/20/2008	S.O. No.	Drawing Revision	B		
Prsht Rev.	NC		Material			
First Issue	/ /	Type	Due Date	Qty:	20	Um:
Previous Run	27683					Each
Written By						
Checked & Approved By	<u>JL 08/02/21</u>					
Comment	Est. A 02.06.06 New Issue NG Est. B Rev B dwg 07-09-25 DD verified by EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B1000X04000	6061-T6 Bar 1.0" x 4.0"	
		Comment: Qty.: 1.8445 f(s)/Unit Total : 36.8907 f(s) 6061-T6 Bar 1.0" x 4.0" Material: M6061-T6 aluminium bar 4.00"x 1.00" Thick Batch: M106348	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 8.500" x 4.000"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2498 Deburr	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

Date: Wednesday, 2/20/2008 4:23:22 PM  
User: Kim Johnston

## Process Sheet

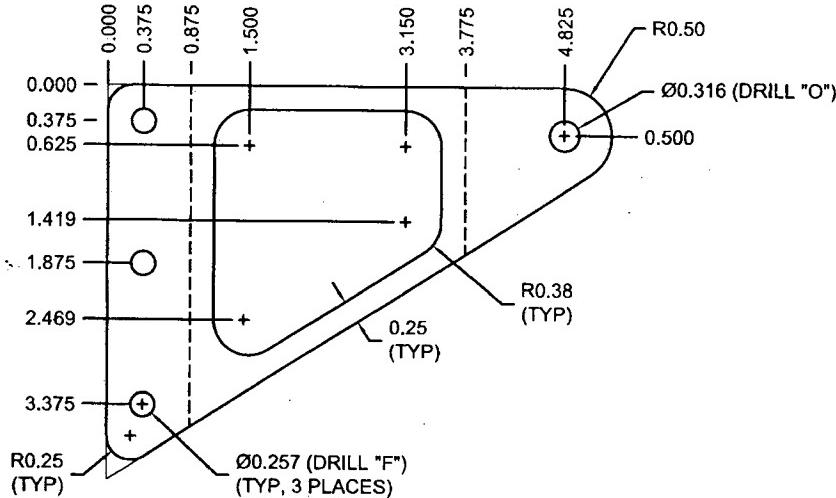
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HI-SKI STEP LEG
Job Number: 37542		Part Number: D2498
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>FK 08/03/18 (20)</i>
7.0	POWDER COATING	POWDER COATING  Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 *****mask slot as per dwg***** <i>M 107005 BK 08-03-18</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>HF 08-03-18 (X20)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 198 <i>AS 08/03/18 (X20)</i>
10.0	QC21	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>AS 08/03/18 (X20)</i>
Job Completion		 <i>MM 2008/3/18 (20)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

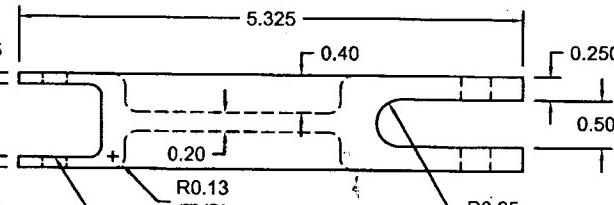
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

07-08-29



## D2498 MOUNT

### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2498" USING FINE POINT  
PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

WORK CENTER  
37542  
STAMP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

B	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
A	NEW ISSUE	KH	95.11.09
REV.	DESCRIPTION		BY DATE
DESIGN	B WILLIAMS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	#	DRAWING NO. D2498	
CHECKED	#	REV. B SHEET 1 OF 1	
MFG. APPR.	#	TITLE MOUNT	
APPROVED	#	SCALE 1:2	
DE APPR.	#		
DATE	07.07.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	Work Order:	37542
Description: MOUNT	Part Number:	D2498
Inspection Dwg: D2498 Rev: B		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	+/- .010	.3745	✓			
0.625	+/- .010	.625	✓			
1.419	+/- .010	1.419	✓			
1.875	+/- .010	1.868	✓			
2.469	+/- .010	2.469	✓			
3.375	+/- .010	3.367	✓			
0.375	+/- .010	0.373	✓			
0.875	+/- .010	0.875	✓			
1.500	+/- .010	1.505	✓			
3.150	+/- .010	3.155	✓			
3.775	+/- .010	3.776	✓			
4.825	+/- .010	4.821	✓			
6.500	+/- .010	6.499	✓			
5.325	+/- .010	5.323	✓			
0.115	+/- .010	0.111	✓			
1.000	+/- .010	0.992	✓			
0.770	+/- .010	0.769	✓			
0.20	+/- .030	0.197	✓			
0.40	+/- .030	0.399	✓			
0.250	+/- .030	0.245	✓			
0.500	+/- .010	0.500	✓			

Measured by:	<i>H.A./JRF</i>
Date:	08/03/16

Audited by:	<i>JG</i>
Date:	08-03-17

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

DART AEROSPACE LTD	Work Order:	37542
Description: MOUNT	Part Number:	D2498
Inspection Dwg: D2498 Rev: B		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## First Article      Prototype

Measured by:	H.A.
Date:	08/03/16

Audited by:	
Date:	08-03-17

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

1